



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7702

Job Sheet 205085



Part No: 647.7702

Job Qty: 10 pcs

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/30/19

Job Tracking No:

Due Date: 2/14/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A2 IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Large Fab - Welded Assy-1	10 pcs	2/14/20		0.00	4.12	Large Fab - 1		MV Feb 24/20
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		K.S. / MV
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
130	QC 9	10 pcs	2/14/20		0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
140	QC 5	10 pcs	2/14/20		0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S258643



Part: 647.7702

Job No: 205085

Serial No/Batch: S258643

Revision: Rev A2

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/26/20

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				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150	Outsource - 3 - Cadplate	10 pcs	2/14/20	GRO002-VC	7
					<i>AB</i> 2020-02-28
160	Packaging 2-1 - Receive - B4B	10 pcs	2/14/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
					Packaging 2 - 37 - B4B
170	QC 6	10 pcs	2/14/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
					<i>DAS</i> MAR 12 2020 40 9-89
180	Spray Paint - 2 - B4B	10 pcs	2/14/20	0.00 0.77	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
190	QC 14	10 pcs	2/14/20	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41

					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	DAS
					QC 14 - 43	81
					QC 14 - 24	9-89
					QC 14 - 61	
					QC 14 - 81	
200	Packaging 3-1 - Stock - B4B	10 ✓ pcs	2/14/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	DAS
					Packaging 3 - 4 - B4B	80
					Packaging 3 - 5 - B4B	9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
210	QC 21 - SA	10 ✓ pcs	2/14/20	0.00 0.00	QC 21 - SA - 21 ✓	
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21

Part Op 120 - (Weld per dwg A/R 4130 rod Batch M127925) 1- ASSEMBLE AND WELD AS PER DWG 0 ***IMPORTANT
 Descriptions: DIMENSION IS 11.60" ***

130 - (QC9- Inspect visual per QSI004- Fusion Welds)

140 - (QC5- Inspect part completeness to step on W/O)

150 - Outsource3 (Outsource process-Cadplate per QSI017 4.1.9.1) Issue P/O : 45978 Group Altech CAD
 PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread

160 - (Receive & Inspect for Damage & Mat'l Certs)

170 - INSPECT USING GO/NO GO GAUGE

180 - (Spray Paint / NDT Room) PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG PRIMER 5236137

BATCH:

190 - (QC14- Inspect Spray Paint)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release) PLEASE NOTE ON PO: Apply only Class 3 Cad to the threaded are only CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7711	Strut Tube	10 pcs (1 ea)	120-Large Fab - Welded Assy-1	5251906 / 5107258
647.7712	Strut Tube	10 pcs (1 ea)	120-Large Fab - Welded Assy-1	x 7 5240366 / 5256207 x3
647.7713	Strut Thread	10 pcs (1 ea)	120-Large Fab - Welded Assy-1	5256860

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Large Fab - Welded Assy-1	647.7711	10	4	0
	647.7712	10	7	0
	647.7713	10	0	0

Part Specifications

Specifications could not be found.

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M#014680

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045978



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045978
PO Date: 2/28/20
Due Date: 3/9/20
Purchase Order Revision:
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

E-MAILED
2020-03-02

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205006	647.7701	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O CAD PLATE IAW QQ-P-416F CLASS I TYPE II Material 4130; RC 33 - NO baking required note: cad plate should not be too thick around tread	Firmed X30	-	3/9/20	30 pcs	0 pcs	30 pcs	\$14.16/pcs	\$424.80
	205084				Firmed X11	-	3/9/20	11 pcs	0 pcs	11 pcs	\$14.16/pcs	\$155.76
								Sub Total:	41	0	41	\$580.56
2	205085	647.7702	647.7700 Rev A2	Strut Assembly : Various STC's Outsource3 (Outsource process- Cadplate per QSI017 4.1.9.1) Issue P/O CAD PLATE IAW QQ-P-416F CLASS I TYPE II Material 4130; RC33 - NO baking required note: cad plate should not be too thick around tread	Firmed X10	-	3/9/20	10 pcs	0 pcs	10 pcs	\$16.37/pcs	\$163.70
	205007				Firmed	-	3/9/20	30 pcs	0 pcs	30 pcs	\$16.37/pcs	\$491.10
								Sub Total:	40	0	40	\$654.80

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Canada

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PURCHASE ORDER

POHB045978



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	206309	647.7703	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O CAD PLATE IAW QQ- P-416F CLASS I TYPE II Material 4130; RC33 - NO baking required ****NOTE: limit cad plating on thread to 0.003" or less****	Firmed X10	-	3/9/20	10 pcs	0 pcs MAR 10 2020	10 pcs	\$12.72/pcs	\$127.20
	203282				Firmed X10	-	3/9/20	10 pcs	0 pcs MAR 10 2020	10 pcs	\$12.72/pcs	\$127.20
Sub Total:								20	0	20		\$254.40

Grand Total: \$1,489.76

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerin

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Certificat de Conformité / Certificate of Compliance

(026741-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

026741 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
09-Mar-2020		SPARTAKOS BOUNTOURIS			POHB045978			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	647.7701 Rev.A2	647.7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD	CADMIUM CH	30	30	0	0	0
2	647.7701 Rev.A2	647.7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD	CADMIUM CH	11	11	0	0	0
3	647.7702 Rev.A2	647.7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD	CADMIUM CH	10	10	0	0	0
5	647-7703 Rev.A2	647-7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS LIMIT CAD PLATING ON THREAD TO 0.0003 " OR LESS	CADMIUM CH	10	10	0	0	0
6	647-7703 Rev.A2	647-7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2, 0.0005 " THICKNESS LIMIT CAD PLATING ON THREAD TO 0.0003 " OR LESS	CADMIUM CH	10	10	0	0	0

RECEIVED
MAR 09 2020
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DAS
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9-88

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

[Signature]

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.